Work Order ID 64155

# PRELIMINARY ISSUMMENTALINA

Page 1

Thursday, November 25, 2010 4:00:49 PM Item ID: D4298-014 Accept Setup Start **PRELIM** Revision ID: Stop Item Name: Hinge 11/25/2010 Start Qty: 1.00 **Start Date: Cust Item ID:** POSITIVE RECALL Required Date: 12/3/2010 Req'd Qty: 1.00 **Customer:** Reference: Start Run Date 10-11-26 **Process Plan:** Tooling: **Approvals:** Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. Work Center ID Description Qty **Run Hours** Code Qty Number Stamp Draw Nbr **Revision Nbr** D4298 PA<sub>1</sub> 100 Cut blanks as per folio 0.00 ont 10/12/08 Bandsaw 0.00 Memo Jeaspa Bandsaw 0.00 110 2/0/12/08 HAAS 1 0.00 Memo HAAS CNC vertical machine #1 on 10/12/09 120 QC2- Inspect parts off machine FAI/FAIB 0.00 QC 0.00 Memo Quality Control

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC-Inspector				
						-				

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Close	d:	Date:

NCR:		W	ORK OR	DER NON-CONFORMANCE	E (NCR)			
		Description of NC Corrective Action Section B		Corrective Action Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector
10/12/08	116	part scrap. The hole are too big. R.C. miss info on the dwg. Pretim process a program	Lasion	screp and replace Oty 1  Botch MI16135  See FAI & Size or FITZ	onl 10/12/09	1012.09	Joseph	110.12.09
			dosimi	FEA Few. D Still Shows A Ø.25 Have ERA approve deviation.			Sim	10117

Work	Or	dar	ID	641	55
WORK	V)r	uer	117	041	7.7

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Item ID:

D4298-014

**Revision ID:** 

**PRELIM** 

Item Name:

Hinge

**Start Date:** 

11/25/2010

Start Qty: 1.00

Required Date: 12/3/2010

Req'd Qty: 1.00



Accept

**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Setup Start

Stop



Reference:

**Approvals:** 

Process Plan:

Date:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID** 

130

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Set Up/ **Run Hours** 

0.00

0.00

Code

Tool # Plan

Accept **Qty** 

Reject **Qty** 

Reject Number

Insp. Stamp

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

Memo JH-03 vern

0.00

10/12/10

150

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Mask large hole before P/C.00

10.(2.09 MID588 START. 840 OVENT. 3200

FINEA: 9:10.

1 bh 18-12-14.

	-								
W/O:			WO	RK ORDER CHANG	GES			182	• . •
DATE	STEP	PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	NCR: Ye	s No DG	)A:	Date: _	<del></del>
	R	esolution:	Disposition	1:	QA: N/C	Closed:		Date: _	
NCR:	NCR:		WORK ORDE	ER NON-CONFORM	IANCE (NO	R)			
DATE	STEP	Description of NC	ļ		ction B		ication	Approval	Approval
DAIL	0,1	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		tion C	Chief Eng	QC Inspector
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V	ork	Or	der	ID	641	55
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Item ID:

D4298-014

**PRELIM** 

Item Name: Hinge

**Start Date:** 

Revision IP:

11/25/2010

Start Qty: 1.00

Required Date: 12/3/2010

Req'd Qty: 1.00



Accept



Setup Start

Stop



**Cust Item ID:** 

**Customer:** 

Reference:

Process Plan:

Date:

**Tooling:** 

Date:

Code

Stop

Start



Approvals:

QC:

Date:\_\_\_\_\_

**SPC (Y/N):** 

Tool ID

Date:

Tool # Plan

Accept Qty

Reject Qty

Reject Insp. Number Stamp

160

Sequence ID/

Work Center ID

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

=) JU 10(12(11

Run

170

Small Fab

Small Fab

Memo

assemble as per dwg

0.00

0.00

0.00

HA => m/h w/21

180

QC5- Inspect part completeness to step on W/O

0.00

Pe 10,12.14



QC

Quality Control

Memo

0.00

	<u> </u>									
W/O:			WO	RK ORDER CHAN	IGES					• '
DATE	STEP	PR	OCEDURE CHAI	NGE	·	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR	l: Yes I	No DQ	A:	Date:	
	Re	esolution:	Disposition:				sed:		Date: _	
NCR: WORK ORDER				R NON-CONFORI	MANCE	(NCR	)			
DATE	OTED	Description of NC		Section B		Verifi	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descriptio Chief Eng	n	Sign & Date		ion C	Chief Eng	QC Inspector
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#### Work Order ID 64155

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Item ID:

D4298-014

PRELIM

Hinge

**Revision ID:** Item Name:

**Start Date:** 

11/25/2010

Start Oty: 1.00

Required Date: 12/3/2010

Req'd Qty: 1.00

Accept

Setup Start

Stop



Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling: SPC (Y/N):

0.00

Set Up/

Date:

Tool ID

**Cust Item ID:** 

**Customer:** 

Date:

Tool # Plan

Code

Run Start

Reject

Qty

Stop



Number Stamp

Insp.

Sequence ID/ Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

B 64166

Date:

Memo

**Run Hours** 0.00

10/12/14

Qty

Accept

Reject

200

OC

**Quality Control** 

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

POSITIVE RECALL EFFECTIVE 10.11. 29 AUTH RELEASED \_\_\_\_\_

10-12-14

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W/O:			W	ORK ORDER CHANG	ES					i e, e
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	C	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Ye	es No	DQ.	A:	Date:	
	Re	esolution:	Disposition	on:	_ QA: N/C	Clos	ed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)				
	0750	Description of NC		·	ion B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		ın & ate		ion C	Chief Eng	QC Inspector
		·								
								•		
_		-1								

Thursday, November 25, 2010 4:00:53 PM

Work Order ID: 64155

Parent Item:

D4298-014

Parent em Name: Hinge



Start Date: 11/25/20: J

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP revA 10.11.25 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.00		Purchased	No			100	f	40.0000	0.25	0.263158	-		
-0 					M116/3	5 X id	10 and	210/12/0	8	)L 10	112107		
M6061-T6 Bar	1,25 × 1,2	50 J.F.	<u>.</u> 5.	Location MAT02	112567	<u>Loc Q</u>		Loc Code		<u>. 27</u>			
MS27980-1B		Purchased	No		Н	170 11 6 354	Each 5	0.0000	I	1 Sø	10/19	1/14	
MS27980-6B		Purchased	No		Ļ	170 1 11625	Each	0.0000	1	1 Sn	10/12	14	

W/O:			W	ORK ORDER CHANG	ES				£,
DATE	STEP	PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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<del>-</del>									
			,						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No DC	A:	Date:	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	OTED	Description of NC	Corrective Action Secti		Verif	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	1& ∣ Sec	tion C	Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order: 10 41 55	
Description: HING-E	Part Number: 104298-7	5/4
Inspection Dwg: DY298 Rev: A	Page 1 of	1

## FIRST ARTICLE INSPECTION CHECKLIST

<u></u>		7	
x	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
. 09	± 030	.090	_		Vern	ML-7	
-83	±. 630	-830			1.		
Ø.399	+ .0000 - 0005	Ø.3986			Micr	ML-8	
.53	£. 030	.528			11		
2.88	±-63b	2.884			1 \	1	
2.62	<del>-</del> . 036	2.620			``	1,	
1.1	±. 630	.407			12	ι,	
2286	±.010	2.288				٨	
8.172	+. 605	Ø.175	_		1		
.19	±.030	.184				ι,	
.23	+.030	.228			,,	N.	
		V) joe das prov					
				,			

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 10/12/01	Date: 4.12.09	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	



